

# Work Order ID 148133

Monday, June 27, 2016 8:35:06 AM

**\*148133\***

Page 1

Item ID: D3704-3 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Escutcheon  
 Start Date: 6/27/2016 Start Qty: 10.00 **\*10\*** Cust Item ID:  
 Required Date: 6/30/2016 Req'd Qty: 10.00 **\*10\*** Customer:  
 Reference:

Approvals: Process Plan: MF Date: 10-6-27 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr                       | Revision Nbr             |                      |         |        |              |               |               |                  |                |
| D3704                          | C U/R                    |                      |         |        |              |               |               |                  |                |

|                                    |                                 |      |  |  |  |  |  |  |                   |
|------------------------------------|---------------------------------|------|--|--|--|--|--|--|-------------------|
| 100                                |                                 | 0.00 |  |  |  |  |  |  | DAS<br>14<br>9-89 |
| <b>*100*</b>                       |                                 |      |  |  |  |  |  |  |                   |
| Bandsaw                            | Memo                            | 0.07 |  |  |  |  |  |  |                   |
| Jeaspa Bandsaw                     | CUT 3.25" LONG                  |      |  |  |  |  |  |  | 16/06/28          |
|                                    |                                 |      |  |  |  |  |  |  |                   |
| 110                                |                                 | 0.00 |  |  |  |  |  |  | DAS<br>14<br>9-89 |
| <b>*110*</b>                       |                                 |      |  |  |  |  |  |  |                   |
| HAAS 1                             | Memo                            | 0.50 |  |  |  |  |  |  |                   |
| HAAS CNC vertical machine #1       | MILL AS PER DWG AND FOLIO FA807 |      |  |  |  |  |  |  |                   |
|                                    | DWG REV: <u>D</u>               |      |  |  |  |  |  |  |                   |
|                                    | FOLIO REV: <u>AA</u>            |      |  |  |  |  |  |  |                   |
|                                    | DEBURR                          |      |  |  |  |  |  |  |                   |
| Haas 5 axis<br>DFB 16/06/27<br>PTO |                                 |      |  |  |  |  |  |  |                   |

DQA:

Date:

16/07/08



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date:

16/07/08

Work Order update only ☐

|                           |                                                                                                                                                                                           |                                               |                                     |                                              |                                      |
|---------------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------|-------------------------------------|----------------------------------------------|--------------------------------------|
| Work Order: <u>148133</u> | <b>DISPOSITION</b><br>Rework <input type="checkbox"/><br>Scrap <input checked="" type="checkbox"/><br>Use-as-is <input type="checkbox"/><br>Suspected Unapproved <input type="checkbox"/> | <b>AGAINST DEPARTMENT/PROCESS</b>             |                                     |                                              |                                      |
| Part No. <u>D3704-3</u>   |                                                                                                                                                                                           | Skid-tube <input type="checkbox"/>            | Cross tube <input type="checkbox"/> | Water Jet <input type="checkbox"/>           | Engineering <input type="checkbox"/> |
| NCR No. <u>16-5883</u>    |                                                                                                                                                                                           | Machining <input checked="" type="checkbox"/> | Small Fab <input type="checkbox"/>  | Prod. Eng. Coord. <input type="checkbox"/>   | Quality <input type="checkbox"/>     |
|                           |                                                                                                                                                                                           | Thermoforming <input type="checkbox"/>        | Finishing <input type="checkbox"/>  | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/>       |
|                           | Large Fab <input type="checkbox"/>                                                                                                                                                        | Composite <input type="checkbox"/>            | Supplier <input type="checkbox"/>   |                                              |                                      |

Date: 16/06/28

Step #: 110

QTY Effective: 1

MRB (QSI042) Approval

DAS

9

9-89 16-06-30

## Description Work Order Deviation

## Disposition

1 part scrap. the .206" slot was over size by .200"

R.C. prog. forgot a tool  
~~prog fix~~

Scrap and destroy  
 replace Qty 1 Batch H134158  
 prog. fix

Completed By

*AFS*  
 16/06/30

Lead hand / Supervisor

Approval Verification

DAS

14

9-89 16/06/30

QC / QA Coordinator

Approval

DAS

9

9-89 16-06-30

## Root Cause

|                                             |                                                           |
|---------------------------------------------|-----------------------------------------------------------|
| Environment <input type="checkbox"/>        | No Re-verification <input type="checkbox"/>               |
| Design <input type="checkbox"/>             | Operator <input type="checkbox"/>                         |
| Doc/Data <input type="checkbox"/>           | Offset/Setup <input type="checkbox"/>                     |
| Equip/Tooling <input type="checkbox"/>      | Supplier <input type="checkbox"/>                         |
| Handling/Pre <input type="checkbox"/>       | Training <input type="checkbox"/>                         |
| Material <input type="checkbox"/>           | Use for Testing <input type="checkbox"/>                  |
| Internal Transport <input type="checkbox"/> | Poor Information <input type="checkbox"/>                 |
| Tribal Knowledge <input type="checkbox"/>   | Rushing <input type="checkbox"/>                          |
| LOA <input type="checkbox"/>                | Product Improvement <input type="checkbox"/>              |
| Substation <input type="checkbox"/>         | Process Improvement <input type="checkbox"/>              |
| Past Expiry Date <input type="checkbox"/>   | <input checked="" type="checkbox"/> Manufacturing Process |
| Misidentified <input type="checkbox"/>      | Past Due <input type="checkbox"/>                         |

## FAULT CATEGORY

|                                                 |                                                            |                                                   |                                               |
|-------------------------------------------------|------------------------------------------------------------|---------------------------------------------------|-----------------------------------------------|
| Pressure/Forced <input type="checkbox"/>        | Temperature/Cure <input type="checkbox"/>                  | Power Loss/Surge <input type="checkbox"/>         | Positioned Wrong <input type="checkbox"/>     |
| Bending <input type="checkbox"/>                | Set-up <input type="checkbox"/>                            | <input checked="" type="checkbox"/> Folio/Program | Outside Dimensions <input type="checkbox"/>   |
| Centre Not Concentric <input type="checkbox"/>  | BOM/Route <input type="checkbox"/>                         | Grain <input type="checkbox"/>                    | Over/Under tolerance <input type="checkbox"/> |
| Cracks <input type="checkbox"/>                 | Broken/Damage/Defect <input type="checkbox"/>              | Weld <input type="checkbox"/>                     | Part Incorrect <input type="checkbox"/>       |
| Crimp/Kink/Ripple/Wave <input type="checkbox"/> | Inspection Incomplete/Unqualified <input type="checkbox"/> | Wrong Stock Pulled <input type="checkbox"/>       | Part Lost/Missing <input type="checkbox"/>    |
| Cuffs <input type="checkbox"/>                  | Contamination <input type="checkbox"/>                     | Out of Sequence <input type="checkbox"/>          | Part Moved <input type="checkbox"/>           |
| Crushing <input type="checkbox"/>               | Countersink <input type="checkbox"/>                       | Off-set <input type="checkbox"/>                  | Drawing <input type="checkbox"/>              |
| Heat Treat <input type="checkbox"/>             | Cut Too Short <input type="checkbox"/>                     | Mislabeled <input type="checkbox"/>               | Finish <input type="checkbox"/>               |
| Wave/Twist in Tube <input type="checkbox"/>     | Instructions Incomplete/Unclear <input type="checkbox"/>   | Fit/Function <input type="checkbox"/>             | Misread <input type="checkbox"/>              |
| Marks/Chatter <input type="checkbox"/>          | Drill Holes <input type="checkbox"/>                       | Misaligned/off center <input type="checkbox"/>    | Turning Sequence <input type="checkbox"/>     |

OTHER:



DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

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| Work Order: _____<br><br>Part No. _____<br><br>NCR No. _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    | <b>DISPOSITION</b><br><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/><br>Suspected Unapproved <input type="checkbox"/> | <b>AGAINST DEPARTMENT/PROCESS</b><br><br><table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube <input type="checkbox"/></td> <td style="border: none;">Cross tube <input type="checkbox"/></td> <td style="border: none;">Water Jet <input type="checkbox"/></td> <td style="border: none;">Engineering <input type="checkbox"/></td> </tr> <tr> <td style="border: none;">Machining <input type="checkbox"/></td> <td style="border: none;">Small Fab <input type="checkbox"/></td> <td style="border: none;">Prod. Eng. Coord. <input type="checkbox"/></td> <td style="border: none;">Quality <input type="checkbox"/></td> </tr> <tr> <td style="border: none;">Thermoforming <input type="checkbox"/></td> <td style="border: none;">Finishing <input type="checkbox"/></td> <td style="border: none;">Rec/Store/Packaging <input type="checkbox"/></td> <td style="border: none;">Other <input type="checkbox"/></td> </tr> <tr> <td style="border: none;">Large Fab <input type="checkbox"/></td> <td style="border: none;">Composite <input type="checkbox"/></td> <td style="border: none;">Supplier <input type="checkbox"/></td> <td></td> </tr> </table> |                                      |                                                 |                                   | Skid-tube <input type="checkbox"/>    | Cross tube <input type="checkbox"/>    | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/>  | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/>            | Thermoforming <input type="checkbox"/>    | Finishing <input type="checkbox"/>        | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | Large Fab <input type="checkbox"/>           | Composite <input type="checkbox"/>  | Supplier <input type="checkbox"/>            |                                           |                                                |                                        |                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                    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| Thermoforming <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 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| Large Fab <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     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| Outside Dimensions <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            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| Over/Under tolerance <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          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| Part Incorrect <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                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| Part Lost/Missing <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             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| Part Moved <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    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| Drawing <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       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| Finish <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        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| Misread <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       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| Turning Sequence <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              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| OTHER : <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       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# Work Order ID 148133

Monday, June 27, 2016 8:35:06 AM

**\*148133\***

Page 3

Item ID: D3704-3 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Escutcheon  
 Start Date: 6/27/2016 Start Qty: 10.00 **\*10\*** Cust Item ID:  
 Required Date: 6/30/2016 Req'd Qty: 10.00 **\*10\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

| Sequence ID/<br>Work Center ID | Operation<br>Description                           | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|----------------------------------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 150                            | QC3- Inspect Part Finish                           | 0.00                 |         |        |              |               |               |                  |                |
| <b>*150*</b>                   |                                                    |                      |         |        |              |               |               |                  |                |
| QC                             | Memo                                               | 0.03                 |         |        |              |               |               |                  |                |
| Quality Control                |                                                    |                      |         |        |              |               |               |                  |                |
| 160                            | Identify as per dwg & Stock Location: <u>ST052</u> | 0.00                 |         |        |              |               |               |                  |                |
| <b>*160*</b>                   |                                                    |                      |         |        |              |               |               |                  |                |
| Packaging                      | Memo                                               | 0.02                 |         |        |              |               |               |                  |                |
| Packaging                      |                                                    |                      |         |        |              |               |               |                  |                |
| 170                            | QC21- Final Inspection - Work Order Release        | 0.00                 |         |        |              |               |               |                  |                |
| <b>*170*</b>                   |                                                    |                      |         |        |              |               |               |                  |                |
| QC                             | Memo                                               | 0.17                 |         |        |              |               |               |                  |                |
| Quality Control                |                                                    |                      |         |        |              |               |               |                  |                |

(10)

DAS  
38  
9-89  
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10X

DAS  
28  
9-89  
JUN 30 2016

16/7/4  
Em 16/06/30

# Picklist Print

Monday, June 27, 2016 8:35:05 AM

Page 1

Work Order ID: 148133

**\*148133\***

Parent Item: D3704-3

**\*D3704-3\***

Parent Item Name: Escutcheon

Start Date: 6/27/2016

Required Date: 6/30/2016

Start Qty: 10.00

Required Qty: 10.00

## Comments:

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M6061T6B1.500X01.25<br>0        |                        | Purchased     |             | No                  |                  |                 | f                  | 13.1310        |             | 2.6          |               |                |        |

**\*M6061T6B1 500X01 250\***

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6061-T6 Bar 1.50 x 1.25

### Location

### Loc Qty

### Loc Code

MAT003

13.131

m134158

13.131

2.85

*ML*  
16/06/28

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

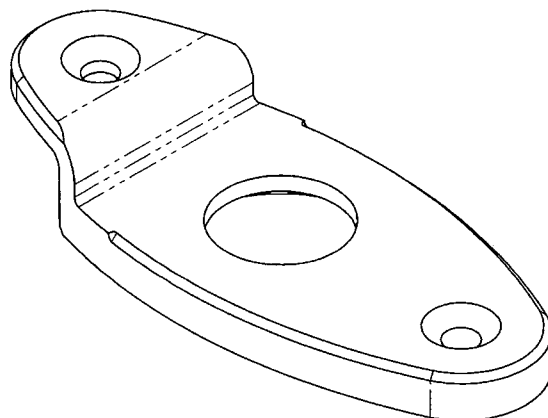


## WORK ORDER NON-CONFORMANCE / UPDATE

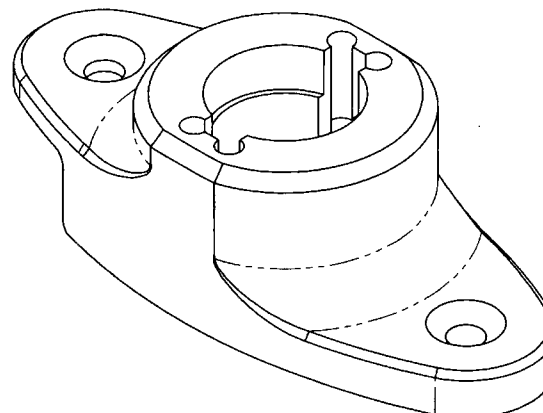
QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

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| Work Order: _____<br><br>Part No. _____<br><br>NCR No. _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |                                                            | <b>DISPOSITION</b><br><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/><br>Suspected Unapproved <input type="checkbox"/> |                                               | <b>AGAINST DEPARTMENT/PROCESS</b><br><br><table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube <input type="checkbox"/></td> <td style="width:15%;">Cross tube <input type="checkbox"/></td> <td style="width:15%;">Water Jet <input type="checkbox"/></td> <td style="width:15%;">Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table> |                                             |                                 |                                   |                                              |                                       | Skid-tube <input type="checkbox"/>     | Cross tube <input type="checkbox"/> | Water Jet <input type="checkbox"/>    | Engineering <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/>       | Prod. Eng. 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| <b>Root Cause</b><br><table style="width:100%; border: none;"> <tr> <td style="width:15%;">Environment <input type="checkbox"/></td> <td style="width:15%;">No Re-verification <input type="checkbox"/></td> </tr> <tr> <td>Design <input type="checkbox"/></td> <td>Operator <input type="checkbox"/></td> </tr> <tr> <td>Doc/Data <input type="checkbox"/></td> <td>Offset/Setup <input type="checkbox"/></td> </tr> <tr> <td>Equip/Tooling <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> </tr> <tr> <td>Handling/Pre <input type="checkbox"/></td> <td>Training <input type="checkbox"/></td> </tr> <tr> <td>Material <input type="checkbox"/></td> <td>Use for Testing <input type="checkbox"/></td> </tr> <tr> <td>Internal Transport <input type="checkbox"/></td> <td>Poor Information <input type="checkbox"/></td> </tr> <tr> <td>Tribal Knowledge <input type="checkbox"/></td> <td>Rushing <input type="checkbox"/></td> </tr> <tr> <td>LOA <input type="checkbox"/></td> <td>Product Improvement <input type="checkbox"/></td> </tr> <tr> <td>Substation <input type="checkbox"/></td> <td>Process Improvement <input type="checkbox"/></td> </tr> <tr> <td>Past Expiry Date <input type="checkbox"/></td> <td>Manufacturing Process <input type="checkbox"/></td> </tr> <tr> <td>Misidentified <input type="checkbox"/></td> <td>Past Due <input type="checkbox"/></td> </tr> </table> |                                                            |                                                                                                                                                                                    |                                               | Environment <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                | No Re-verification <input type="checkbox"/> | Design <input type="checkbox"/> | Operator <input type="checkbox"/> | Doc/Data <input type="checkbox"/>            | Offset/Setup <input type="checkbox"/> | Equip/Tooling <input type="checkbox"/> | Supplier <input type="checkbox"/>   | Handling/Pre <input type="checkbox"/> | Training <input type="checkbox"/>    | Material <input type="checkbox"/>  | Use for Testing <input type="checkbox"/> | Internal Transport <input type="checkbox"/> | Poor Information <input type="checkbox"/> | Tribal Knowledge <input type="checkbox"/> | Rushing <input type="checkbox"/>   | LOA <input type="checkbox"/>                 | Product Improvement <input type="checkbox"/> | Substation <input type="checkbox"/> | Process Improvement <input type="checkbox"/> | Past Expiry Date <input type="checkbox"/> | Manufacturing Process <input type="checkbox"/> | Misidentified <input type="checkbox"/> | Past Due <input type="checkbox"/> | <b>FAULT CATEGORY</b><br><table style="width:100%; 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| Handling/Pre <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  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| Material <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      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| Internal Transport <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            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| Tribal Knowledge <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              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| LOA <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           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| Substation <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    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| Past Expiry Date <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              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| Misidentified <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 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| Pressure/Forced <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               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| Bending <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       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| Centre Not Concentric <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         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| Cracks <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        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| Crimp/Kink/Ripple/Wave <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        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| Cuffs <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         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| Crushing <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      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| Heat Treat <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            | Cut Too Short <input type="checkbox"/>                     | Mislabeled <input type="checkbox"/>                                                                                                                                                | Finish <input type="checkbox"/>               |                                                                                                                                                                                                                                                                                                                                              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| Wave/Twist in Tube <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            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| Marks/Chatter <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         | Drill Holes <input type="checkbox"/>                       | Misaligned/off center <input type="checkbox"/>                                                                                                                                     | Turning Sequence <input type="checkbox"/>     |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |                                             |                                 |                                   |                                              |                                       |                                        |                                     |                                       |                                      |                                    |                                          |                                             |                                           |                                           |                                    |                                              |                                              |                                     |                                              |                                           |                                                |                                        |                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         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                            |                                             |                                                |                                    |                                |                                               |                                 |                                               |                               |                                         |                                                 |                                                            |                                             |                                            |                                |                                        |                                          |                                     |                                   |                                      |                                  |                                  |                                     |                                        |                                     |                                 |                                             |                                                          |                                       |                                  |                                        |                                      |                                                |                                           |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |                                                            |                                                                                                                                                                                    |                                               | OTHER : <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |                                             |                                 |                                   |                                              |                                       |                                        |                                     |                                       |                                      |                                    |                                          |                                             |                                           |                                           |                                    |                                              |                                              |                                     |                                              |                                           |                                                |                                        |                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         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                            |                                             |                                                |                                    |                                |                                               |                                 |                                               |                               |                                         |                                                 |                                                            |                                             |                                            |                                |                                        |                                          |                                     |                                   |                                      |                                  |                                  |                                     |                                        |                                     |                                 |                                             |                                                          |                                       |                                  |                                        |                                      |                                                |                                           |



**D3704-1 ESCUTCHEON**



**D3704-3 ESCUTCHEON**

**NOTES:**

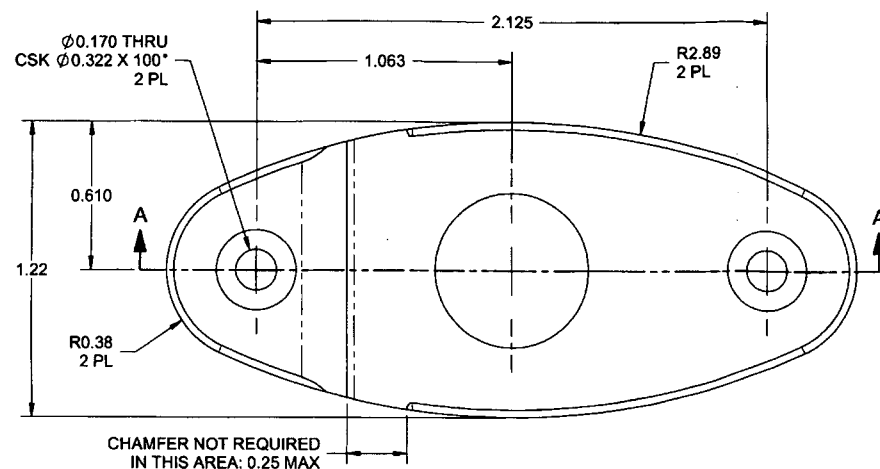
- 1) MATERIAL: 6061-T6 (OR 6061-T651/-T6510/-T6511/-T62) BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3704-X" AND B/N PER DART QSI 044 6.1 (PERMANENT INK MARKER)
- 7) WEIGHT:
  - D3704-1 = 0.04 lbs
  - D3704-3 = 0.11 lbs

| D          | D3704-1: TOLERANCE CHANGE ZN A5-2 (WAS +0.005/-0.001). REVISED D3704-3. REF: NCR16-5827 AND CIR16-71.            | AK                                                                                                                                                                                                                                                                                      | 16.06.03     |
|------------|------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|
| C          | $\Phi 0.630 +0.005/-0.000$ WAS $\Phi 0.628$ (ZN B5-3); $0.725$ WAS $0.685$ (ZN B5-4). REASON: PAR12-188/CIR12-4. | MB                                                                                                                                                                                                                                                                                      | 12.09.05     |
| B          | ADDED D3704-3. REASON: COMPATIBILITY WITH AA1'S HANDLE.                                                          | MB                                                                                                                                                                                                                                                                                      | 09.03.17     |
| A          | NEW ISSUE                                                                                                        | MB                                                                                                                                                                                                                                                                                      | 08.02.05     |
| REV.       | DESCRIPTION                                                                                                      | BY                                                                                                                                                                                                                                                                                      | DATE         |
| DESIGN     | AJS                                                                                                              | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA                                                                                                                                                                                                                                |              |
| DRAWN      | AK                                                                                                               |                                                                                                                                                                                                                                                                                         |              |
| CHECKED    | MB                                                                                                               | DRAWING NO.                                                                                                                                                                                                                                                                             | REV. D       |
| MFG. APPR. | JFS                                                                                                              | <b>D3704</b>                                                                                                                                                                                                                                                                            | SHEET 1 OF 3 |
| APPROVED   | HS                                                                                                               | TITLE                                                                                                                                                                                                                                                                                   | SCALE        |
| DE APPR.   | DS                                                                                                               | <b>ESCUTCHEON</b>                                                                                                                                                                                                                                                                       | NTS          |
| DATE       | 16.06.03                                                                                                         | COPYRIGHT © 2006 BY DART AEROSPACE LTD<br><small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> |              |

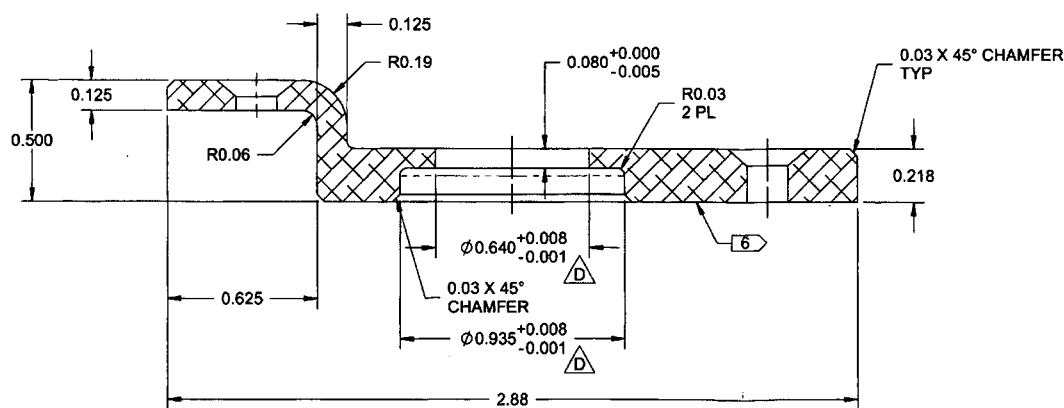
**RELEASED**  
2016-06-24  
EEN 16-577

APPROVED





**D3704-1 ESCUTCHEON**

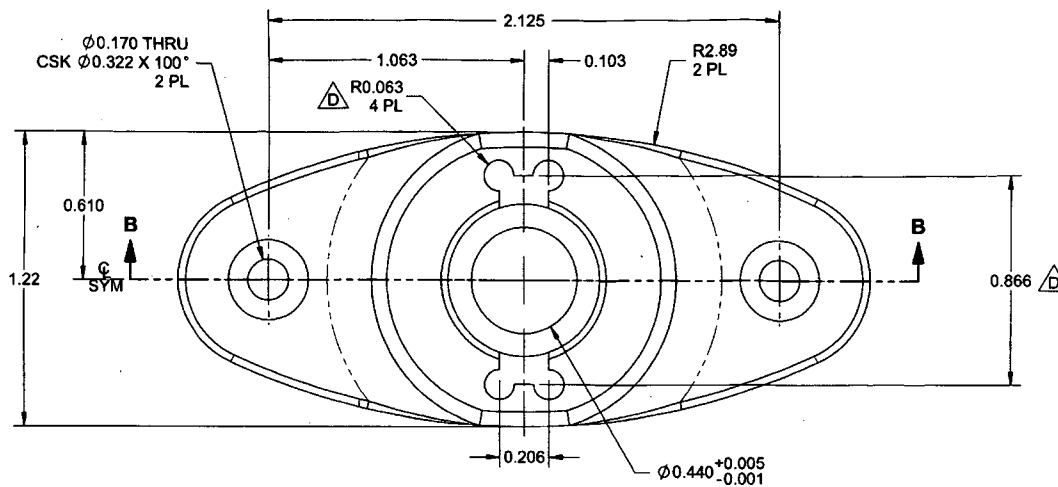


**SECTION A-A**

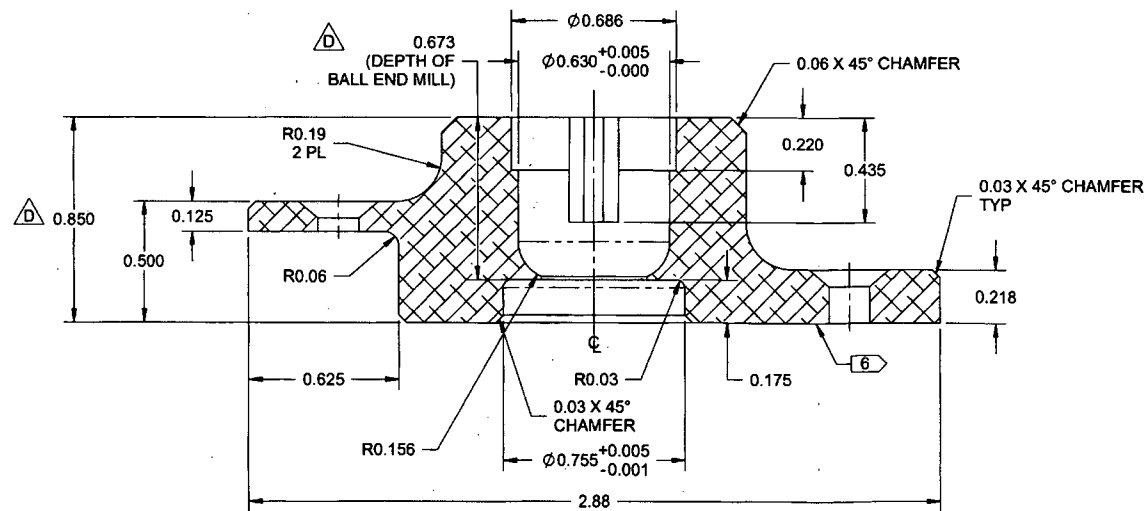
|                                                                                                                                                                                                                                |          |                                        |              |
|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------|----------------------------------------|--------------|
| DESIGN                                                                                                                                                                                                                         | AJS      | <b>DART AEROSPACE LTD</b>              |              |
| DRAWN                                                                                                                                                                                                                          | AK       | HAWKESBURY, ONTARIO, CANADA            |              |
| CHECKED                                                                                                                                                                                                                        | MB       | DRAWING NO.                            | REV. D       |
| MFG. APPR.                                                                                                                                                                                                                     | JFS      | <b>D3704</b>                           | SHEET 2 OF 3 |
| APPROVED                                                                                                                                                                                                                       | HS       | TITLE                                  | SCALE        |
| DE APPR.                                                                                                                                                                                                                       | DS       | <b>ESCUTCHEON</b>                      | NTS          |
| DATE                                                                                                                                                                                                                           | 16.06.03 | COPYRIGHT © 2008 BY DART AEROSPACE LTD |              |
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**RELEASED**  
2016-06-24

APPROVED



**D3704-3 ESCUTCHEON**



**SECTION B-B**

|                                                                                                                                                                                                                                |          |                                        |              |
|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------|----------------------------------------|--------------|
| DESIGN                                                                                                                                                                                                                         | AJS      | <b>DART AEROSPACE LTD</b>              |              |
| DRAWN                                                                                                                                                                                                                          | AK       | HAWKESBURY, ONTARIO, CANADA            |              |
| CHECKED                                                                                                                                                                                                                        | MB       | DRAWING NO.                            | REV. D       |
| MFG. APPR.                                                                                                                                                                                                                     | JFS      | <b>D3704</b>                           | SHEET 3 OF 3 |
| APPROVED                                                                                                                                                                                                                       | HS       | TITLE                                  | SCALE        |
| DE APPR.                                                                                                                                                                                                                       | DS       | <b>ESCUTCHEON</b>                      | NTS          |
| DATE                                                                                                                                                                                                                           | 16.06.03 | COPYRIGHT © 2006 BY DART AEROSPACE LTD |              |
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RELEASED  
2016-06-24

|                                            |  |                             |
|--------------------------------------------|--|-----------------------------|
| <b>DART AEROSPACE LTD</b>                  |  | <b>Work Order:</b> 148133   |
| <b>Description:</b> ESCUTCHEDW             |  | <b>Part Number:</b> D3704-3 |
| <b>Inspection Dwg:</b> D3704 <b>Rev:</b> D |  | <b>Page 1 of 1</b>          |

### INSPECTION SHEET

| Drawing Dimension | Tolerance      | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|----------------|------------------|--------|--------|----------------------|----------|
| 2.125             | ±0.05          | 2.124            | ✓      |        | Vern HL06            |          |
| 1.063             | ±0.05          | 1.061            | ✓      |        | "                    |          |
| .103              | ±0.10          | .105             | ✓      |        | "                    |          |
| R.063             | ±0.10          | R.063            | ✓      |        | "                    |          |
| .866              | ±0.10          | .865             | ✓      |        | "                    |          |
| Ø.440             | ±.005<br>±.005 | Ø.441            | ✓      |        |                      |          |
| .206              | ±0.10          | .206             | ✓      |        | "                    |          |
| 1.22              | ±0.30          | 1.219            | ✓      |        | "                    |          |
| .610              | ±0.10          | .608             | ✓      |        | "                    |          |
| Ø.170             | ±.005<br>±.005 | Ø.171            | ✓      |        | "                    |          |
| Ø.322 x 100°      | ±0.10 X ±1/2°  | .325 x 100°      | ✓      |        | "                    |          |
| .850              | ±0.10          | .853             | ✓      |        | "                    |          |
| .500              | ±0.10          | .502             | ✓      |        | "                    |          |
| .125              | ±0.10          | .127             | ✓      |        | "                    |          |
| R.19              | ±0.30          | R.190            | ✓      |        | R-G                  |          |
| .673              | ±0.10          | .672             | ✓      |        | Vern HL06            |          |
| Ø.686             | ±0.10          | Ø.686            | ✓      |        | "                    |          |
| Ø.630             | ±.005<br>±.005 | Ø.631            | ✓      |        | "                    |          |
| .06 x 45°         | ±0.30          | .06 x 45°        | ✓      |        | "                    |          |
| .220              | ±0.10          | .219             | ✓      |        | "                    |          |
| .435              | ±0.10          | .437             | ✓      |        | "                    |          |
| .030 x 45°        | ±0.30          | .030 x 45°       | ✓      |        | "                    |          |
| .218              | ±0.10          | .221             | ✓      |        | "                    |          |
| .175              | ±0.10          | .174             | ✓      |        | "                    |          |
| Ø.755             | ±.005<br>±.005 | Ø.755            | ✓      |        | "                    |          |
| .03 x 45°         | ±0.30          | .030 x 45°       | ✓      |        | "                    |          |
| R.03              | ±0.30          | R.030            | ✓      |        | R-G                  |          |
| 2.88              | ±0.30          | 2.872            | ✓      |        | Vern HL06            |          |
| .625              | ±0.10          | .617             | ✓      |        | "                    |          |
| R.06              | ±0.30          | R.060            | ✓      |        | R-G                  |          |
|                   |                |                  |        |        |                      |          |
|                   |                |                  |        |        |                      |          |

|                               |                       |                      |
|-------------------------------|-----------------------|----------------------|
| <b>Measured by:</b> DAS<br>14 | <b>Checked by:</b> J1 | <b>QC Inspector:</b> |
| <b>Date:</b> 14/06/30         | <b>Date:</b> 16-6-30  | <b>Date:</b>         |

|                                                |              |
|------------------------------------------------|--------------|
| <b>Engineering Approval:</b><br>(If necessary) | <b>Date:</b> |
|------------------------------------------------|--------------|

| Rev | Date     | Change    | Revised by | Approved |
|-----|----------|-----------|------------|----------|
| B   | 14.07.31 | New Issue | KJ         |          |